

Work Order ID 60046

Wednesday, June 23, 2010 1:12:12 PM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 6/23/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-06-23 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr							
D3916	A							

100



Large Fab

Memo

0.00

(b) GL 10-07-20

Large Fab

- 1- Cut tube 50"
 2- Bend tube with manuel pipe bender as per DT9567
 *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
 3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605
 5- weld bushing as per dwg D3916
 6- grind welds flush

SAO 10-07-13

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S1010721

Memo

0.00

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Item Name: Rib Assembly

Start Date: 6/23/2010 Start Qty: 6.00



Required Date: 6/30/2010 Req'd Qty: 6.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 10/07/2010

76

130



Packaging

Packaging

Identify as per dwg & Stock Location: CWA

0.00

SAO

36

10-07-21

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/2010

MF

10-7-21

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Ficklist Print

Wednesday, June 23, 2010 1:12:16 PM

Page 1

Work Order ID: 60046



Parent Item: D3916-041



Parent Item Name: Rib Assembly

Start Date: 6/23/2010

Required Date: 6/30/2010

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	90.0000	7	42		P/L 10-07-20	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	90.0000	7	42		P/L 10-07-20	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	441.5314	4.166	26.31158		B60190 → 40 B60241 → 2	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	441.5314	4.166	26.31158		SAD 10-07-13	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	441.5314	4.166	26.31158		26.31158	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

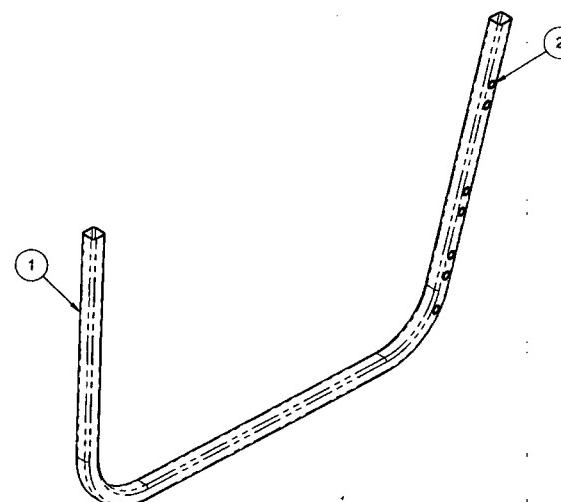
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

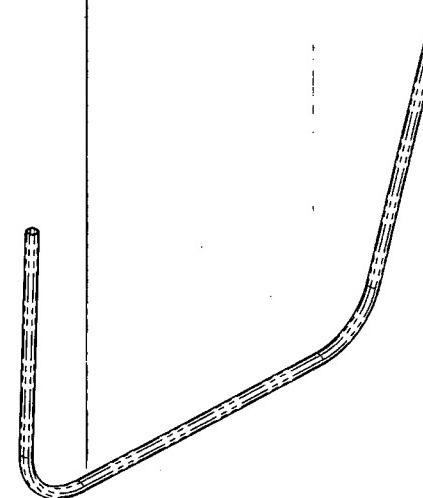
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 600-516

BS10-6-23

RELEASED
2010-03-12
MP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>QO</i>	DRAWING NO.	
MFG. APPR.	<i>EZ</i>	REV. A	
APPROVED	<i>MP</i>	SHEET 1 OF 4	
DE APPR.	<i>MP</i>	TITLE	
DATE	10.03.04	SCALE	
		NTS	
RIB ASSY, 350 BASKET			

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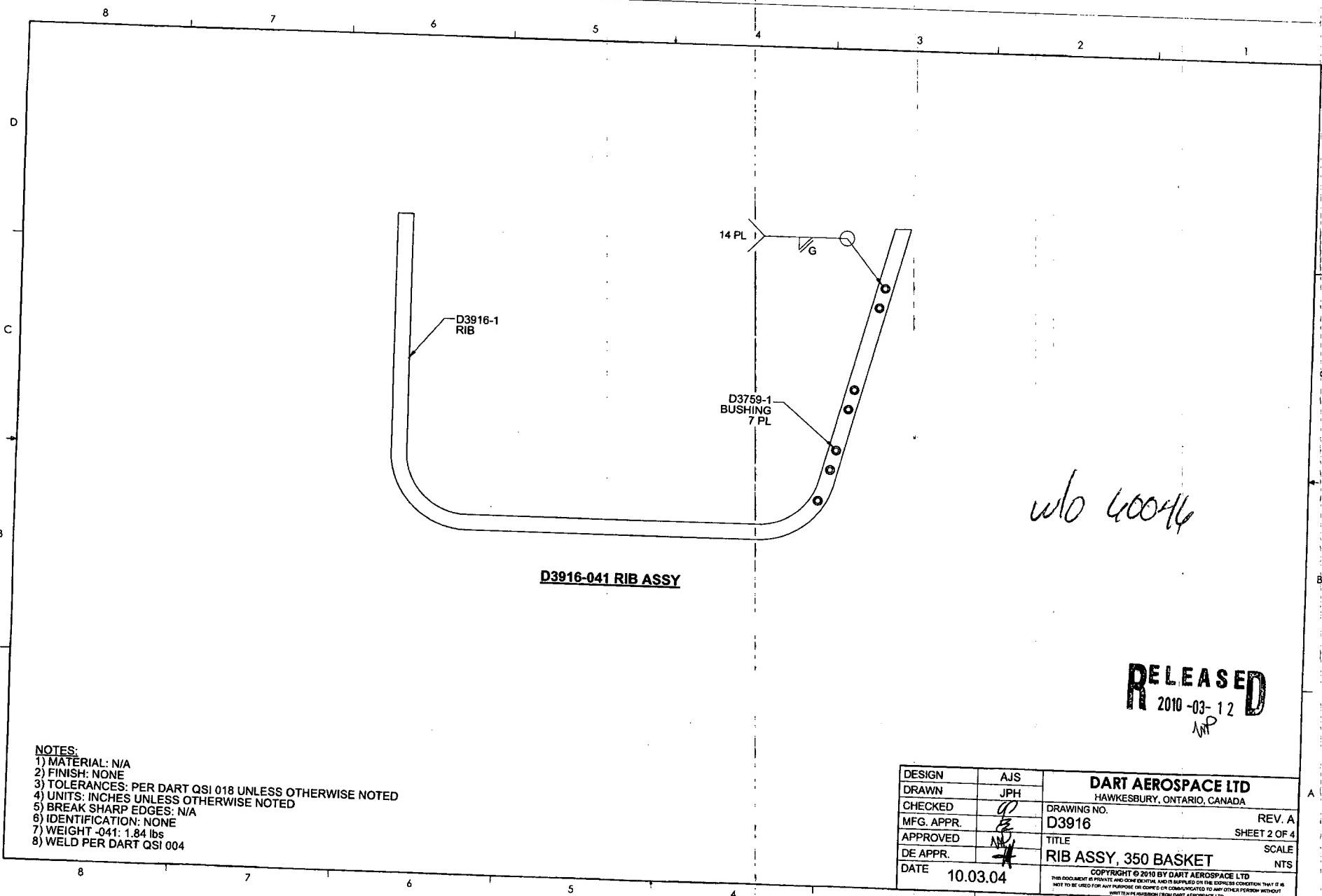
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DRAWN	AJS JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>		DRAWING NO. D3916
MFG. APPR. <i>[Signature]</i>		REV. A SHEET 2 OF 4
APPROVED <i>[Signature]</i>		TITLE RIB ASSY, 350 BASKET
DE APPR. <i>[Signature]</i>		SCALE NTS
DATE 10.03.04		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
2010-03-12
[Signature]

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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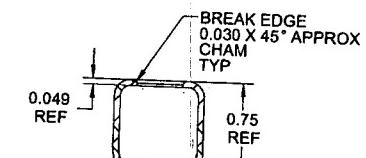
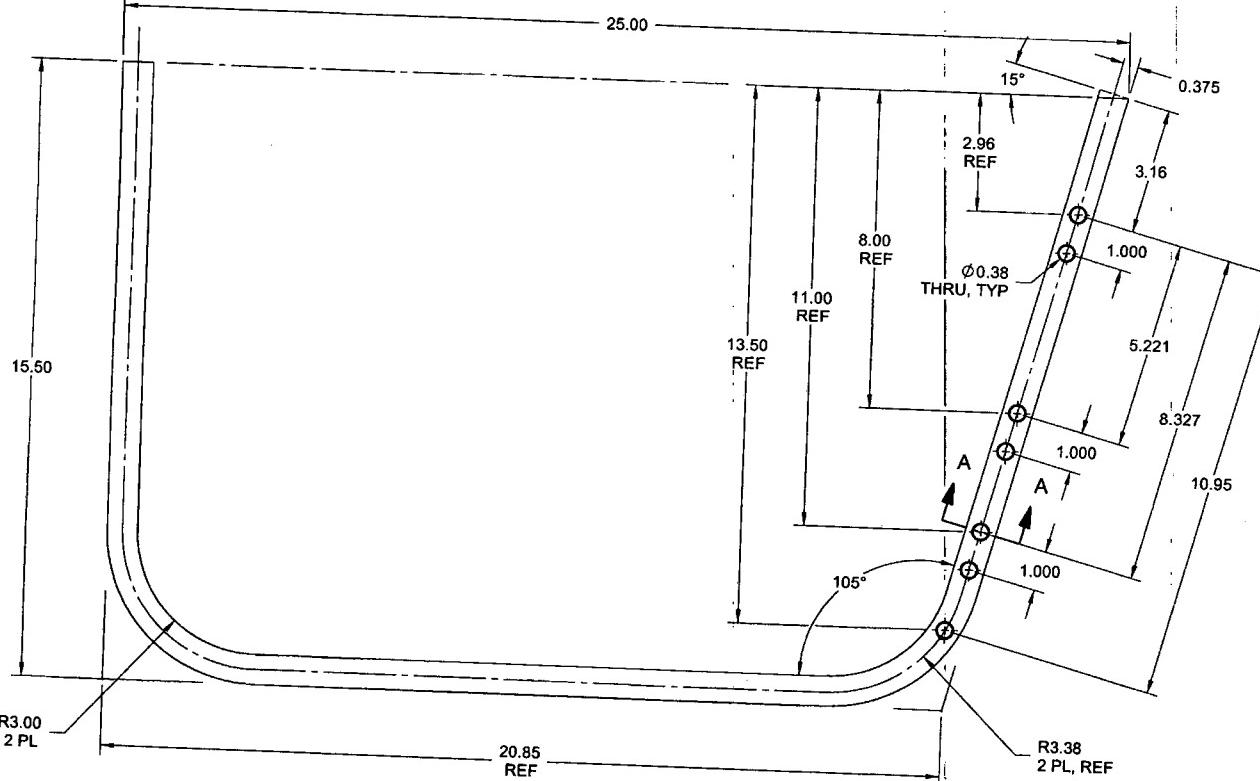
B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

R3.00

2 PL

20.85
REF9) D3916-1 RIBSECTION A-A

W6

60046
RELEASED
2010-03-12
NP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	99	
MFG. APPR.	E	
APPROVED	NV	
DE APPR.	NV	
DATE	10.03.04	REV. A SHEET 3 OF 4 NTS

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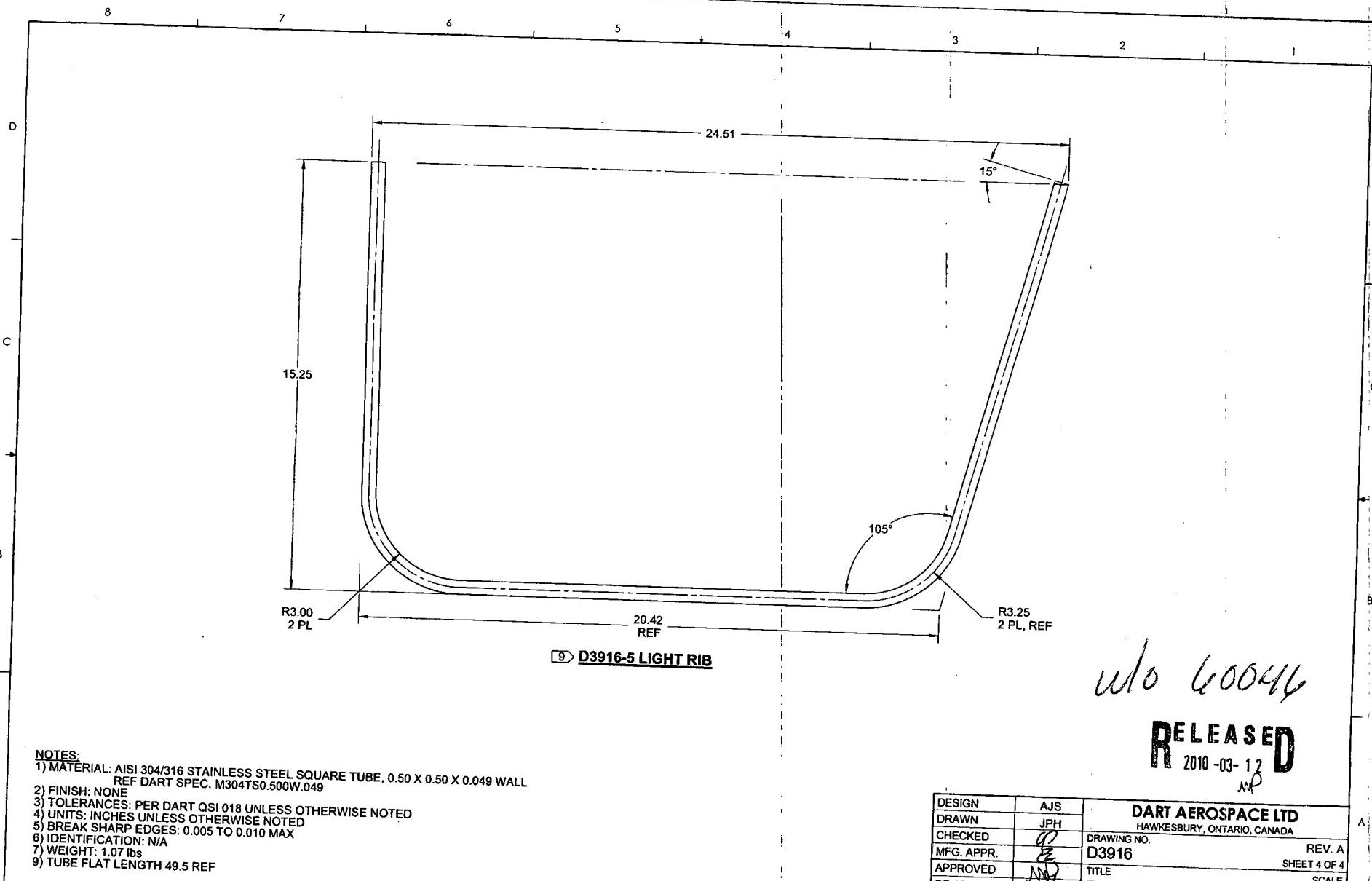
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REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 8) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3916
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 4 OF 4
DATE	10.03.04	TITLE
		RIB ASSY, 350 BASKET
		SCALE
		NTS

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